

**SYSTEM, METHOD AND COMPUTER-PROGRAM PRODUCT  
FOR TRANSFERRING A NUMERICAL CONTROL PROGRAM  
TO THEREBY CONTROL A MACHINE TOOL CONTROLLER**

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**ABSTRACT OF THE DISCLOSURE**

A DNC system, method and computer-program product that utilize a wide area network (WAN), such as the Internet, to transfer numerical control (NC) programs to thereby control machine tool controllers is provided. The DNC system consists of at least one central processing element that includes at least one numerical  
10 NC program, and a workstation connected to the central processing elements via the WAN for selecting desired NC programs. Additionally, the system includes at least one machine tool controller for receiving the selected NC programs across the WAN from the central processing elements. Based upon the selected NC programs, the machine tool controllers can control the at least one machine tool during a  
15 manufacturing process. The system can further include at least one server processing element connected to the central processing elements via the WAN, and electrically connected to the machine tool controllers.